Work Ordenseptember-11-1				*106	3743*						Page 1
Item ID: Revision ID:	D4009-3			Accept	*N900	040	100	<b>)</b> * ፡	Setup Sta	art *\	IS1*
Item Name:	Ground Strap	16							Ste	op <b>* \</b>	IS2*
Start Date:	9/11/13	Start Qty: 12.00	*12*		Cust Item	m.				11	1. 7/
Required Date:		Req'd Qty: 12.00			Cust mem Customer:	iD:					
Reference:	. 5/11/15	100 12.00	*12*		Customer.						
Approvals:	Process Pla	n: MLJ	Date: 13-19-16	Tooling:	D	ate:		I	Run Sta St	!/	IR1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:				" * <b>\</b>	IR2*
Sequence ID/ Work Center II	 D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr					•		• • • • • • • • • • • • • • • • • • • •		
D4009	A										2.
100				0.00				10			11
*100*								16X			4)13/0
Small Fab		Memo		0.00				,, _			
Small Fab		1- Cut to siz	e as per dwg D4009								
										į	
110		QC5- Inspect part compl	eteness to sten on W/O	0.00		1	اس مد :			•	· ~
*110*	ı	QCS mspeet part comp	econosis to stop on was	0.00	/	130	5%	16			
QC		Memo		0.00		1 de		<u> </u>			(3
Quality Control											
								•			*
120		Identify as per dwg & Ste	ock Location:	0.00					/= -		
*120*								Vov	J. Bago	13-0	9-18
Packaging		Memo		0.00				147	<b>See</b> 1		-
Packaging											

										DQA:	Date	•
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE	QA Closed:	Date	•
NAC - III O II I	<u>.</u>				DISPOSITION				AGAINST DE		· · · · · · · · · · · · · · · · · · ·	•
Work Orde	er:				Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	o				Scrap		ľ	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR N	lo	·			Use-as-is Work Order Update	_	1	Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Π	Initial	Acti	on	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator		İ										
Material												
Setup												
Other												
Process	_										:	
Supplier	_											
Fraining				•1								
Jnapproved												<u> </u>
						AUL	T CATE	GORY			·	
Landir	ng Gear				General	_	7			7	_	<b>-</b> 1
	Bending				Bend	L	Grain			Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		4 '	on incomplete	_	Part Incorre	·	Weld
	Crushed/	Crimped			Burrs	$\perp$	₹	ions Incomplete/U	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
ļ	Cuffs				Contamination	L	Mainte			Part Moved		
ļ	Heat Trea				Countersink	L	Mislabe	led		Positioned V		<b>-</b>
	Inspectio		Tube		Cut Too Short	$\vdash$	Misread		<u></u>	Power Loss/	Surge	Other
	Ripples in	n Bend 💂			Drill Holes	L	Offset					

Out of Calibration
Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Torque Waves in Extrusion
Turning Sequence

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord				*106	3743*						Page 2
Item ID: Revision ID:	D4009-3			Accept	*N900	040	100	)*	Setup		*NS1*
Item Name:	Ground Strap									Stop	*NS2*
Start Date: Required Date	9/11/13	Start Qty: .12.00 Req'd Qty: 12.00	*12*		Cust Item I Customer:	D:					
Reference:	9/11/13		*12*		Customer.						
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	- -		Run	Start	*NR1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:				Stop	*NR2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Insp. Number Stamp
130		QC21- Final Inspection -	Work Order Release	0.00						ا م	1 alix DA
*130* QC Quality Control		Memo		0.00						17	19/18/7
Quality Control									q	hy g	M

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **DISPOSITION AGAINST DEPARTMENT/PROCESS** Work Order: Water Jet Skid-tube Engineering Crosstube Rework Machining Part No. Scrap Small Fab Prod. Eng. Coor. Quality Use-as-is Thermoforming Finishing Rec/Store/Packaging Other Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Action Sign & Initial Root Verification Step Qty or Non-conformance Chief Eng Description QC Inspector Cause Date Date Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

Landing (	Gear	General				_	_
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	_
	Heat Treat	Countersink	Г	Mislabeled	Г	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			,

**FAULT CATEGORY** 

September-11-13 11:35:16 AM

Work Order ID:

106743

Parent Item;

D4009-3

Parent Item Name:

Ground Strap

**Start Date:** 9/11/13

Required Date: 9/11/13

**Start Qty:** 12.00

Required Qty: 12.00

Comments:

IPP rev A 09.12.23 new Issue Prelim EC verified by: DD

IPP Rev:B 10.05.03 as per ECN10-

562	חח	verified	by FC
30/	1 ) 1 )	vermea	DV: FA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4009		Manufactured	No			100	f	95.6250	0.125	1.5	9/		0/1
Ground Strap					-				<del></del>		fe)	0 /0	27/1
				<u>Location</u>		Loc Qty	<u>Lo</u>	c Code				/	
				GA		3.5	•						
				725	38	3.5					M	(2	<del>3</del> 7 5
				st251C		92.125			<u> </u>		Jet	TO STORY	10
				101	142	92.125			LE				

NCR:	Yes	1	No
NUN.	162	,	INU

NCR:	es/	/ No					<b>WORK ORDER NON-O</b>	100	<b>NFORM</b>	MANCE / UPI	DATE					
													QA Closed:	Da	te:	
Work Orde	er:						DISPOSITION			· ·	AGAINST I	DE	PARTMENT	/PROCESS		
Part N	۱o. ِ						Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab		4	Water Jet d. Eng. Coor.		Engineering Quality
NCR I	۱o. ِ		<u></u>				Use-as-is Work Order Update	]	l .	noforming Large Fab	Finishing Composite		Rec/Sto	e/Packaging Supplier		Other
Root					Desc	rip	tion of work order update		nitial	Act	ion		Sign &			
Cause		Date	Step Qty or Non-conformance		r Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	n	QC Inspector		
oc/Data								1								
quip/Tooling													:			
perator																
laterial																
etup																
ther																
rocess			1		İ								·			
upplier					İ									•		
raining													į			
napproved			L					<u> </u>								
								AUL	T CATE	GORY	·			·	—	
Landi					Г	_	General	_	۱		Г		۱		$\overline{}$	n /= 1
		Bending			}		Bend	$\vdash$	Grain		-		Ovalized			Pressure/Forced
		Centre No	ot Concer	itric to	<sup>0/S</sup>	$\dashv$	BOM/Route	<u> </u>	Hardwa		-		Over/Under		$\boldsymbol{\vdash}$	Temperature/Cure
		Cracks			-	$\neg$	Broken/Damaged	$\vdash$	4	on Incomplete			Part Incorre		-	Weld
		Crushed/0	Crimped		-	-	Burrs	<u> </u>	4	ions Incomplete/L	Inclear		Part Lost/Mi	ssing	Ш	Wrong Stock Pulled
		Cuffs			-	_	Contamination	<u></u>	Mainte		}		Part Moved			
		Heat Trea			-	$\dashv$	Countersink	$\vdash$	Mislabe		}		Positioned V	_		
		Inspection		Tube		-	Cut Too Short	<b>—</b>	Misread	l	Ĺ		Power Loss/	Surge	Ш	Other
		Ripples in					Drill Holes	<u></u>	Offset					· ·		
		Torque W			n		Drawing	<u> </u>	4	Calibration			<del></del>			
		Turning S				_	Finish	_	1	Sequence						
		Maya /Tw	ict in Tub	10			Folio	1	I Outcido	Dimoncione						

DQA: Date:

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4009-3	REF JCA-M47-4-01
D4009-5	REF JCA-M47-4-01

## **SPECIFICATION CONTROL DRAWING**

106743 MUJ 13-09-16

DART PART NUMBER	LENGTH					
D4009-3	1.5					
D4009-5	13.5					

## **D4009-X GROUND STRAP**

NOTES:
1) MATERIAL: MADE FROM AVIALL P/N 1171 (OR SEA-171) OR C.O.R.E. AVIATION P/N QQ8575R36T250
2) FINISH: N/A:
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR.

HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4009

REV. A SHEET 3 OF 5 SCALE

GROUND STRAP

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DATE 10.02.05

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